

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2017-74 Date Opened: 20 April 2017 Title: FabricationAircraft OEM: Robinson Aircraft Model: R44 Product Type: Cargo Basket Product Model: Landing Gear Adapters Quantity: 7 sets**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

JC
N/A
JC
N/A
N/A
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JC
JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
90640	0	Landing Gear Adapters	JC

Traveller

Initial or N/A

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

7 sets
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Work performed by:

Print: J. Clarke

Sign: J. Clarke

SCA: AD02

Date: 15-May-17

ICC / Dual Inspection performed by:

Print: J. Rekve

Sign: J. Rekve

SCA: AD01

Date: 15-May-17

Work Order closed by:

Print: J. Clarke

Sign: J. Clarke

SCA: AD02

Date: 15-May-17

Approved Manufacturing Facility 73-04

Form 2010.03

Rev. Original 23 Sep 2014



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

- 4 PAINTED + COMPLETE JC 03 MAY 2017
- 24 ANODIZE COMPLETE JC 12 MAY 2017
- 24 Helical installed JC 15 MAY 2017



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

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AMF 73-04

Nomenclature: Forward clamp-threaded No. of pieces: 28

Manufacturer: Aero design LTD.

Part No.: 90640-03 Serial/Batch No.: PO. 16023

TTSN: AVA TSO: N/A Rem.: N/A

Work Order No.: 2017-74

Remaining Tasks to be Performed: Clean up, Inspection, Surface
Finish, HELICOIL ✓ ✓ ✓

Signature: JH CRL.

Date: 21 APR 2017 Lic. No. / SCA 4002

In Process



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AMF 73-04

In Process

Remarks

-4 PAINTED + COMPLETE JC 03 MAY 2017
-24 ANODIZE COMPLETE JC 12 MAY 2017
-24 Helicoil installed JC 15 MAY 2017



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AMF 73-04

Nomenclature: Aft clamp - threaded No. of pieces: 28

Manufacturer: Aero design LTD.

Part No.: 90640-0618 05 Serial/Batch No.: PO. 16023

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-74

Remaining Tasks to be Performed: Clean up, inspection, surface
finish, HENCOIL ✓

Signature: JH Cal.

Date: 21 APR 2017 Lic. No. / SCA AD02

In Process



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AMF 73-04

Remarks

In Process

-4 PRINTED + COMPLETE JC 03 MAY 2017
-24 ANODIZE COMPLETE JC 24 MAY 2017



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AMF 73-04

Nomenclature: Aft clamp - thru No. of pieces: 28

Manufacturer: Aero design LTD.

Part No.: 90640-06 Serial/Batch No.: P.O 16023

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-74

Remaining Tasks to be Performed: Clean up, inspection, surface
Finish ✓ ✓ ✓

Signature: Jff Cal.

Date: 21 APR 2017 Lic. No. / SCA AD02

In Process



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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: ADAPTER No. of pieces: 1/1/1/1

Manufacturer: AERO DESIGN LTD.

Part No.: 90640-03/-04/-05/-06 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-74

Remaining Tasks to be Performed: PAINT BLACK ✓

Signature: Jff CCL

Date: 15 MAY 2017 Lic. No. / SCA A002

In Process



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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

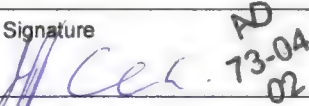
Remarks

PAINTED 12 JUNE 2018 JC.

ASSEMBLED w/ #8-32 x0.75 STAINLESS CAP SCREW PO 12046

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2018-0154	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice PO2_180608_001A	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
1.	Forward Adapter	90640-01	2	WO 2017-74	New	
2.	Aft Adapter	90640-02	2	WO 2017-74		
12. Remarks Certification data: TCCA STC SH10-48; EASA STC 10050758 Black						
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 15 June 2018		14d. Name		14e. Date (dd/mmm/yyyy)
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

PERGAM SUISSE

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2018-0013
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2017-74
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Forward Adapter	90640-01	2	N/A	New
2.	Aft Adapter	90640-02	2		
12. Remarks Aft Adapters painted black.					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12. Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 15 Jan 2018		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

ALASKA CHANNEL



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AMF 73-04

Nomenclature: FWD CLAMP-THRU No. of pieces: 1

Manufacturer: AERO DESIGN LTD

Part No.: 90640-04 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-74

Remaining Tasks to be Performed: NONE

Signature: JH Carl

Date: 05 MAY 2017 Lic. No. / SCA ADC2

Serviceable



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AMF 73-04

Remarks

Serviceable



Aero Design Ltd.

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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: FWD ADAPTER ASSY No. of pieces: 1

Manufacturer: AERO DESIGN LTD.

Part No.: 90640-01 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-74

Remaining Tasks to be Performed: NONE

Signature: [Signature]

Date: 05 MAY 2017 Lic. No. / SCA AD 02

Serviceable



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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Serviceable

Remarks

HEUCIL 3585-2ENL4

12021

#8-32 x 3/4 SHCS

12046



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AFT ADAPTER ASSY No. of pieces: 2

Manufacturer: AERO DESIGN LTD

Part No.: 98640-C2 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-74

Remaining Tasks to be Performed: NONE

Signature: J/CCL

Date: 05 MAY 2017 Lic. No. / SCA AD02

Serviceable



Aero Design Ltd.

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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Serviceable

Remarks

HELICOIL 3585-2CN164 12021

#8-32 x 3/4 SHCS 12046



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AFT CLAMP - THREADED No. of pieces: 1

Manufacturer: AERO DESIGN LTD.

Part No.: 90640-05 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-74

Remaining Tasks to be Performed: NONE

Signature: [Signature]

Date: 05 MAY 2017 Lic. No. / SCA AD02

Serviceable



Aero Design Ltd.

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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Serviceable

Remarks

Helicoid 3585-2CN164

12021

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2017-0187
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2017-74
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Forward Adapter	90640-01	10	N/A	New
2.	Aft Adapter	90640-02	10		
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12. Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 15 May 2017		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

LANDING GEAR ADAPTER - 90640

General

These instructions apply to Landing Gear Adapters for the Robinson R44. Refer to the following drawings, at the current revision, for dimensions and details:

90640, Revision 0 – Adapter Assembly

Work Order: 2017-74

Batch Qty: 7 sets

Complete
(initial or SCA #)

Date Open: 20 APR 2017

AD
73-04
02

1. Stock Preparation

- Cut 1.5 x 2.0 6061-T6 Aluminum bar at 13.63+ long.
- Record material PO:
- De-burr cut ends.
- Tag stock bars and place into CNC shop for machining.

Aluminum Bar: 16023

AD
73-04
02

2. Machining

- Run CNC programs to machine parts into stock.
 - Ensure tap is cleared between each threaded hole
- Update tag following machining.

AD
73-04
02

3. Cut Parts From Stock

- On vertical bandsaw, setup fence to cut parts from stock. Ensure parts are over 1.01 high, they will be faced to final height on CNC.
- Update tag for stock parts and place into CNC shop for machining.

AD
73-04
02

4. Machining

- Run CNC program to machine parts to height.
- Update tag following machining.

KB

5. Clean Up

- Deburr parts on buffing wheel, and deburr holes.
- Ensure threaded holes are threaded deep enough (min 0.25)
- Update tag following clean up.

6. Inspection

To be performed by a different person than the above steps.

- Inspect parts for conformity to drawing.
- Update tag following inspection.

AD
73-04
01

7. Surface Finish

- Parts are to be painted or anodized in accordance with the drawing.
- If parts are anodized, record PO:
- Update tag following surface finish.

AD
73-04
02

Anodizing: 17045

LANDING GEAR ADAPTER – 90640

Complete
(initial or SCA #)

AD
73-04
02

8. Assembly

- a. Install #8-32 helicoil in threaded holes.
- b. Assemble parts with #8-32 x 0.75 socket head cap screws.
- c. Record PO:

3585-2CN164 Helicoil: 12021 (6) / 15042
#8-32 x 0.75 Socket Head Cap Screw: 12046

AD
73-04
01

9. Final Inspection

To be performed by a different person than the above step.

- a. Inspect parts for conformity to drawing.
- b. Green tag or issue Form One for completed assemblies.



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AMF 73-04

Nomenclature: Forward clamp - thru No. of pieces: 28

Manufacturer: Aero design LTD.

Part No.: 90640-04 Serial/Batch No.: P.C 16023

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-74

Remaining Tasks to be Performed: Clean up, inspection, surface
Finish

Signature: [Signature]

Date: 24 APR 2017 Lic. No. / SCA 4002

In Process



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AMF 73-04

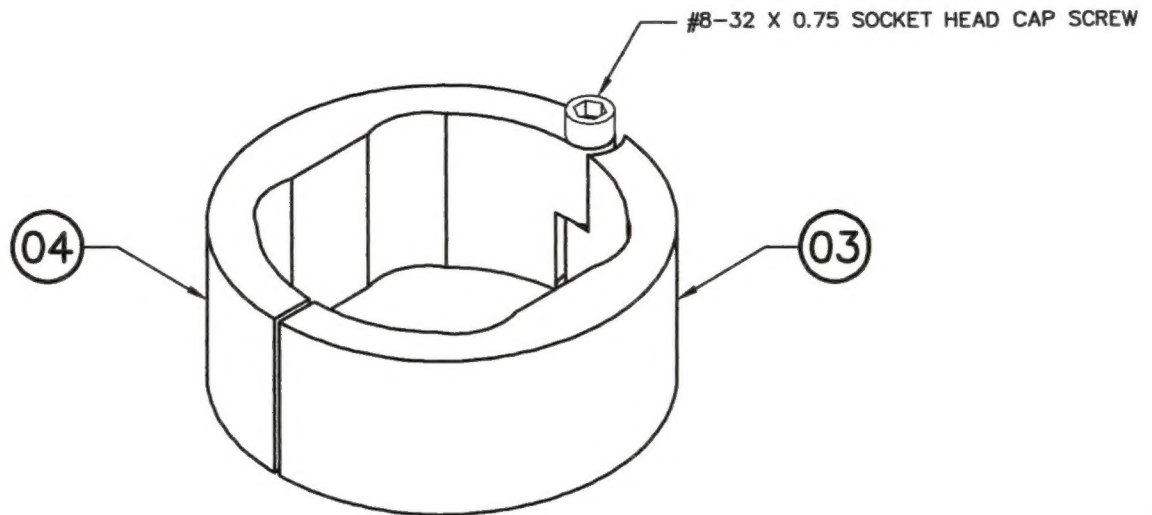
In Process

Remarks

-4 PAINTED + COMPLETE JC 03 MAY 2017
-24 ANODIZE COMPLETE JC 12 MAY 2017

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



(01) FORWARD ADAPTER ASSEMBLY

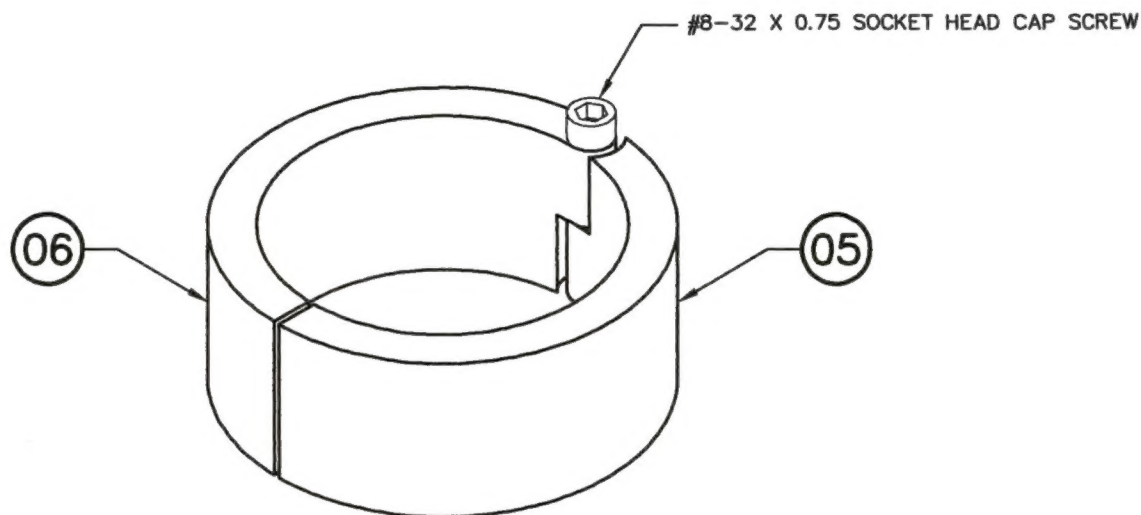
NOTES

- DO NOT TIGHTEN #8-32 SCREW, PARTS MUST BE FREE TO ROTATE.

1	#8-32 X 0.75		SOCKET HEAD CAP SCREW	STAINLESS STEEL	COMMERCIAL	
1	90640-04	04	FORWARD CLAMP - THRU	6061-T6 ALUMINUM	QQ-A-200/B	1.5 X 2 BAR
1	90640-03	03	FORWARD CLAMP - THREADED	6061-T6 ALUMINUM	QQ-A-200/B	1.5 X 2 BAR
	90640-01	01	FORWARD ADAPTER ASSEMBLY			
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

LIST OF MATERIALS

<div> <div>APPROVALS</div> <div>DATE</div> </div> <div> <div>DRAWN: JEFF CLARKE</div> <div>05 OCT 2016</div> </div> <div> <div>CHECKED: JASON REKVE</div> <div>05 OCT 2016</div> </div> <div> <div>UNLESS OTHERWISE SPECIFIED</div> <div>DIMENSIONS ARE IN INCHES.</div> <div>TOLERANCES ON:</div> <div> <div>DECIMALS</div> <div>ANGLES</div> </div> <div> <div>X.XXX ±0.010</div> <div>±1/2°</div> </div> <div> <div>X.XX ±0.03</div> </div> <div> <div>X.X ±0.1</div> </div> </div>	<div> <div>AERO DESIGN LTD.</div> <div>9888A MALASPINA ROAD</div> <div>POWELL RIVER, BC, CANADA, V8A 0G3</div> <div>TEL: 604.483.2376</div> <div>www.aerodesign.ca</div> </div>		<div> <div>ROBINSON R44, R44 II - REVISED LANDING GEAR</div> <div>QUICK RELEASE CARGO BASKET INSTALLATION</div> <div>LANDING GEAR ADAPTER FABRICATION</div> </div>		
	SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.	
	SHEET 1 OF 4	A4	90640	0	




(02) AFT ADAPTER ASSEMBLY

NOTES

1. DO NOT TIGHTEN #8-32 SCREW, PARTS MUST BE FREE TO ROTATE.

1	#8-32 X 0.75		SOCKET HEAD CAP SCREW	STAINLESS STEEL	COMMERCIAL	
1	90640-06	06	AFT CLAMP - THRU	6061-T6 ALUMINUM	QQ-A-200/8	1.5 X 2 BAR
1	90640-05	05	AFT CLAMP - THREADED	6061-T6 ALUMINUM	QQ-A-200/8	1.5 X 2 BAR
	90640-02	02	AFT ADAPTER ASSEMBLY			


02	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

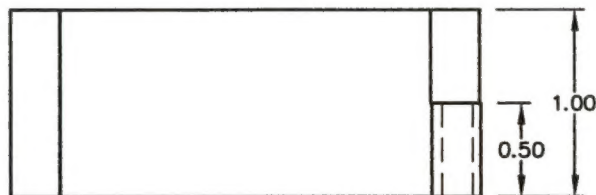
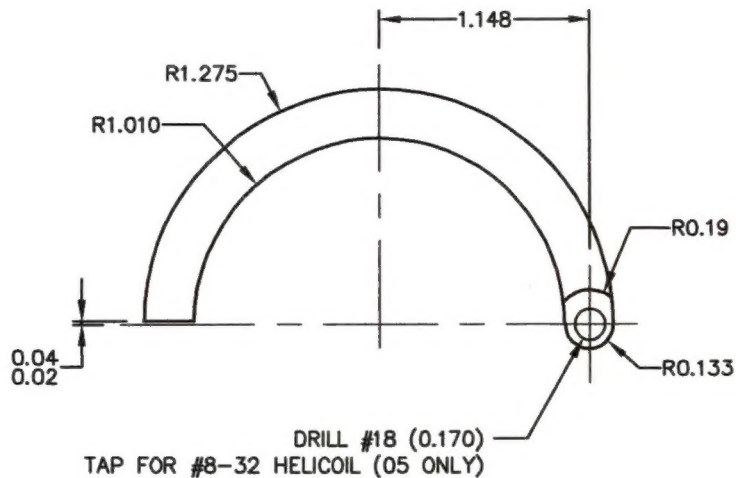
APPROVALS		DATE		<div>AERO DESIGN LTD.</div> <div>9888A MALASPINA ROAD</div> <div>POWELL RIVER, BC, CANADA, V8A 0G3</div> <div>TEL: 604.483.2376 www.aerodesign.ca</div>			
DRAWN:	JEFF CLARKE	05 OCT 2016					
CHECKED:	JASON REKVE	05 OCT 2016					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1			ROBINSON R44, R44 II – REVISED LANDING GEAR QUICK RELEASE CARGO BASKET INSTALLATION LANDING GEAR ADAPTER FABRICATION				
			SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.	
			SHEET 2 OF 4	A4	90640	0	



④ FORWARD CLAMP – THRU

	1	3585-2CN164		#8-32 SELF LOCKING HELICOIL			
		90640-04	04	FORWARD CLAMP - THRU	6061-T6 ALUMINUM	QQ-A-200/8	1.5 X 2 BAR
		90640-03	03	FORWARD CLAMP - THREADED	6061-T6 ALUMINUM	QQ-A-200/8	1.5 X 2 BAR
04	03	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	QTY	LIST OF MATERIALS					

	APPROVALS		DATE			AERO DESIGN LTD.					
	DRAWN: JEFF CLARKE		05 OCT 2016			9888A MALASPINA ROAD					
	CHECKED: JASON REKVE		05 OCT 2016			POWELL RIVER, BC, CANADA, V8A 0G3					
					TEL: 604.483.2376		www.aerodesign.ca				
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1				ROBINSON R44, R44 II – REVISED LANDING GEAR QUICK RELEASE CARGO BASKET INSTALLATION LANDING GEAR ADAPTER FABRICATION						
				SCALE 1 : 1		DWG. SIZE		DWG. NO.		REV.	
				SHEET 3 OF 4		A4		90640		0	




⑤ AFT CLAMP – THREADED
⑥ AFT CLAMP – THRU

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. THOROUGHLY DEGREASE, ALODINE, PRIME AND PAINT ALL ALUMINUM PARTS PRIOR TO ASSEMBLY.
ALTERNATE: ANODIZE ALL ALUMINUM PARTS IN ACCORDANCE WITH MIL-A-8625F, TYPE II.

	1	3585-2CN164		#8-32 SELF LOCKING HELICOIL			
		90640-06	06	AFT CLAMP - THRU	6061-T6 ALUMINUM	QQ-A-200/8	1.5 X 2 BAR
		90640-05	05	AFT CLAMP - THREADED	6061-T6 ALUMINUM	QQ-A-200/8	1.5 X 2 BAR
06	05	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	QTY	LIST OF MATERIALS					

<div>APPROVALS</div>		<div>DATE</div>	<div>AERO DESIGN LTD.</div>				
<div>DRAWN: JEFF CLARKE</div>		<div>05 OCT 2016</div>	<div>9888A MALASPINA ROAD</div>				
<div>CHECKED: JASON REKVE</div>		<div>05 OCT 2016</div>	<div>POWELL RIVER, BC, CANADA, V8A 0G3</div>				
			<div>TEL: 604.483.2376</div>				
			<div>www.aerodesign.ca</div>				
<div>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:</div>			<div>ROBINSON R44, R44 II – REVISED LANDING GEAR QUICK RELEASE CARGO BASKET INSTALLATION LANDING GEAR ADAPATER FABRICATION</div>				
<div>DECIMALS</div>		<div>ANGLES</div>	<div>SCALE 1 : 1</div>		<div>DWG. SIZE</div>	<div>DWG. NO.</div>	<div>REV.</div>
<div>X.XXX ±0.010</div>		<div>±1/2°</div>	<div>SHEET 4 OF 4</div>		<div>A4</div>	<div>90640</div>	<div>0</div>
<div>X.XX ±0.03</div>							
<div>X.X ±0.1</div>							